



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2264
Job Sheet 178157



Part No: D2264

Job Qty: 10 ea

Part Name: S-76 Cushion



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/28/18

Job Tracking No:

Due Date: 6/25/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A New Issue 07-07-16 JLM Verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		6/25/18	0.00	0.00	Start Up Waterjet		OK 18/05/30
100	Waterjet	10 pcs		6/25/18	0.00	0.49	Waterjet1		OK 18/05/30
120	QC	10 pcs		6/25/18	0.00	0.00	QC2 Waterjet-4		OK 18/05/30
140	QC	10 pcs		6/25/18	0.00	0.00	QC8-7		38
150	Packaging	10 pcs		6/25/18	0.00	0.00	Packaging3 Large Fab		57005 JUN 04 2018
160	QC21-SA	10 Ea		6/25/18	0.00	0.00	QC21		21 JUN 04 2018

Part Op 100 - 1-Cut as per Dwg D2264 Dwg Rev: B Prog Rev: B 2-Debur if necessary
Descriptions:

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MNEO60S.063	Neoprene Sheet 0.063	.0300 sf (.003 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MNEO60S.063	0	285	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Cushion	0.700Inches $\pm$ 0.030	0.730 0.670		
2	Cushion	0.750Inches $\pm$ 0.030	0.780 0.720		
3	Cushion	0.188Inches + 0.005 - 0.001	0.193 0.187	Diameter	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Cross tube ☐ Small Fab ☐ Finish ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐				
Date : _____	Step #: _____	MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval				
Descriptic 						
Root Cause <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:50%; border-right: 1px solid black;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:50%;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>		Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	☐ Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence		
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DART Aerospace Ltd.
 1270 Aberdeen Street
 Hentleybury, ON K64 1K7
 CANADA N12 6S2 - 6200
 TEL.: sales@dartaero.com
 Email: sales@dartaero.com
 www.dartaerospace.com



Container No: S076632



Part: D2264
 Job No: 178157
 Serial No/Batch: S076632

Revision: B

Inspector:

Exp Date: 05/30/2018

Instructions:

Date: 05/30/18

Cuffs
 Crushing
 Heat Treat
 Wave/Twist in Tube
 Marks/Chatter

broken/Damage/Defect
 Inspection Incomplete/Unqualified
 Contamination
 Countersink
 Cut Too Short
 Instructions Incomplete/Unclear
 Drill Holes

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

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